

shp. 23/01

Work Order ID 78523

January-12-12 8:55:53 AM

78523

Page 1

Item ID: D3005-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 1/10/12 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 1/24/12 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: W Date:

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3005	Rev A
-------	-------

101		0.00							
-----	--	------	--	--	--	--	--	--	--

101

Waterjet

Memo

0.00

FLOW CNC Waterjet

cut per drwg D3005 Rev.A
Rev. A

12-1-13

(2)

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC

Memo

0.00

Quality Control

12-1-13

130	QC8- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--

130

QC

Memo

0.00

Quality Control

8/26/15

(2)

Work Order ID 78523

78523

Page 2

January-12-12 8:55:53 AM

Item ID: D3005-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearplate

Stop

NS2

Start Date: 1/10/12

Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/24/12

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

140

Large Fab

Large Fab

Large Fab

Memo

Weld 7560 hardcoat & D3009 cup-as per dwg D3005 & QSI 004

M 9326 - ERTOS-6 (mild steel)

M 117964 - 228 hardcoat.

0.00

0.00

Q 12-1-17 (X2)

150

150

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

2 0 BE 12-1-18

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/12/01/19

(X2)

Work Order ID 78523

78523

Page 3

January-12-12 8:55:53 AM

Item ID: D3005-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearplate

Stop ***NS2***

Start Date: 1/10/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/24/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

170

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

170

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20
320 OF
9:50
286

2XØ M-12/01/19

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Packaging

Memo

0.00

2 Ø M-12/01/19
COUNTED

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Quality Control

Memo

0.00

12/1/20

M.L.J 12/01/20
2

Picklist Print

January-10-12 2:43:29 PM

Page 1

Work Order ID: 78523

78523

Parent Item: D3005-041

D3005-041

Parent Item Name: Wearplate

Start Date: 10/01/2012

Required Date: 24/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A01.04.04New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No			140	sf	86.0000	1.1597	2.441474			

M1010S16GA

1010/1025 sheet 16GA

**

12-1-13

Location

Loc Qty

Loc Code

MAT019

86

116791

27.4

117500

26.6

118965

32

116791

(2)

D3009-1

Manufactured No

100

Each

124.0000

8

16

D3009-1

Cup

**

12-1-17

Location

Loc Qty

Loc Code

WA030

124

36482

71

37488

53

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

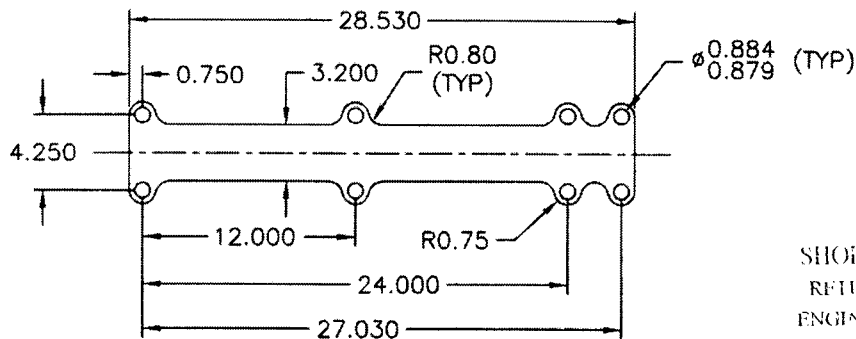
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3005	REV. A SHEET 1 OF 1
DATE 01.03.23		TITLE WEARPLATE	SCALE 1:10
A	01.03.23	NEW ISSUE	

RELEASED
01.04.09

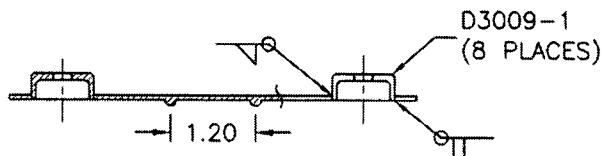
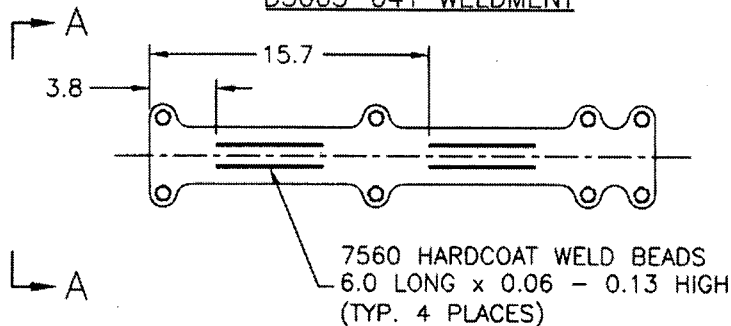
D3005-1 FLAT PATTERN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38523-M.L.J

12/01/10

D3005-041 WELDMENT



SECTION A-A
(ROTATED 90° CCW, SCALE 2:5)

BREAK ALL SHARP EDGES 0.010 TO 0.020

WELD PER QSI 004

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 SERIES STEEL 16
GAUGE (0.060 THICK)

FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

